

**Work Order ID 80606****\*80606\***

Page 1

February-23-12 2:55:06 PM

Item ID: D4419-3

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Aft Support Plate

Start Date: 24/02/2012 Start Qty: 8.00

**\*8\***

Cust Item ID:

Required Date: 09/03/2012 Req'd Qty: 8.00

**\*8\***

Customer:

Reference:

Approvals: Process Plan: M.L.J.Date: 12/02/23 Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4419	A								
100		0.00							
<b>*100*</b>									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									

W 12.02.26 (7)

W 12.02.26 (7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 80606****\*80606\***

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February-23-12 2:55:06 PM

Item ID: D4419-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Aft Support Plate  
Start Date: 24/02/2012 Start Qty: 8.00 **\*8\*** Cust Item ID:  
Required Date: 09/03/2012 Req'd Qty: 8.00 **\*8\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC8- Inspect parts - second check 0.00

**\*120\***

QC

Memo

Quality Control

0.00

5/26/28

(77)

130

Identify as per dwg & Stock Location: **390**

0.00

**\*130\***

Packaging

Memo

Packaging

0.00

12/2/29 (77)

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

Quality Control

0.00

MCS 12/02/29

12-22-29

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

February-23-12 2:55:11 PM

Page 1

Work Order ID: 80606

\*80606\*

Parent Item: D4419-3

\*D4419-3\*

Parent Item Name: Aft Support Plate

Start Date: 24/02/2012

Required Date: 09/03/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No				sf	58.0000		2.910316			

\*M304S11GA\*

304/316 0.125 Sheet

\*\*

W 12.02.26

Location

Loc Qty

Loc Code

MAT020

58

120243

26

120604

32

232

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	80606
Description: Aft Support Plate		Part Number:	D4419-3
Inspection Dwg: D4419 Rev: A		Page 1 of 2	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.133	✓		VhrN	WB-02
Ø0.191	+0.005/-0.001	0.191	✓		VhrN	" "
Ø0.250	+0.005/-0.001	0.250	✓		VhrN	" "
Ø0.53	+0.008/-0.001	0.53	✓		VhrN	" "
5.55	+/-0.030	5.555	✓		VhrN	
5.27	+/-0.030	5.278	✓		VhrN	
4.25	+/-0.030	4.256	✓		VhrN	
2.80	+/-0.030	2.78	✓		VhrN	
0.40	+/-0.030	0.410	✓		VhrN	
3.83	+/-0.030	3.838	✓		VhrN	
5.56	+/-0.030	5.558	✓		VhrN	
6.26	+/-0.030	6.26	✓		VhrN	
7.14	+/-0.030	7.139	✓		VhrN	
7.73	+/-0.030	7.737	✓		VhrN	
0.31	+/-0.030	0.31	✓		VhrN	
0.38	+/-0.030	0.385	✓		VhrN	
0.750	+/-0.010	0.750	✓		VhrN	
1.53	+/-0.030	1.538	✓		VhrN	
0.390	+/-0.010	0.390	✓		VhrN	
0.450	+/-0.010	0.448	✓		VhrN	
1.67	+/-0.030	1.675	✓		VhrN	
10.55	+/-0.030	10.55	✓		M.T	MM-02
8.00	+/-0.030	8.00	✓		M.T	
6.02	+/-0.030	6.02	✓		M.T	
1.10	+/-0.030	1.009	✓		VhrN	HB-02
1.20	+/-0.030	1.208	✓		VhrN	
0.50	+/-0.030	0.506	✓		VhrN	
1.500	+/-0.010	1.508	✓		VhrN	
0.60	+/-0.030	0.610	✓		VhrN	
2.300	+/-0.010	2.302	✓		VhrN	
0.63	+/-0.030	0.627	✓		VhrN	
0.991	+/-0.010	0.993	✓		VhrN	
0.440	+/-0.010	0.440	✓		VhrN	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	80606
<b>Description:</b> Aft Support Plate		<b>Part Number:</b>	D4419-3
<b>Inspection Dwg:</b> D4419	<b>Rev:</b> A	<b>Page 2 of 2</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.760	+/-0.010	0.768	✓		vern	
0.125	+/-0.010	0.118	✓		vern	
0.063	+/-0.010	0.065	✓		vern	
0.900	+/-0.010	0.910	✓		vern	
0.375	+/-0.010	0.375	✓		vern	
1.17	+/-0.030	1.172	✓		vern	
0.750	+/-0.010	0.755	✓		vern	
0.125	+/-0.010	0.118	✓		vern	

<b>Measured by:</b>	W/W	<b>Audited by:</b>		<b>Preliminary Approval:</b>	
<b>Date:</b>	12.02.26	<b>Date:</b>		<b>Date:</b>	
<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>	
A	11.08.22	New Issue	KJ		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



SHOOTING  
RIFLE  
FIRE  
UNCOMMON  
SUBJECT  
WATER  
A  
NO - 80606 M.C.J  
12/02/23

RELEASED  
2011-07-28

**NOTES:**  
1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA OR M303S11GA

- 2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: NONE  
7) WEIGHT -1: 0.88 lbs  
              -3: 1.10 lbs

A	NEW ISSUE		AJS	11.07.06
REV.		DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D4419</b>  TITLE <b>BASKET SUPPORT PLATES</b>	REV. A	
DRAWN	AJS		SHEET 1 OF 3	
CHECKED	4/		SCALE	
MFG. APPR.	E		NTS	
APPROVED	10			
DE APPR.	11			
DATE	11.07.06	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AJS IS REVOKED OF THE LICENSE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMBOS OF COMBINATIONS TO ANY OTHER PERSON WITHOUT		

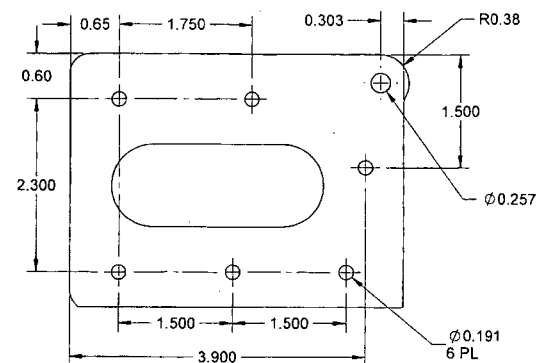
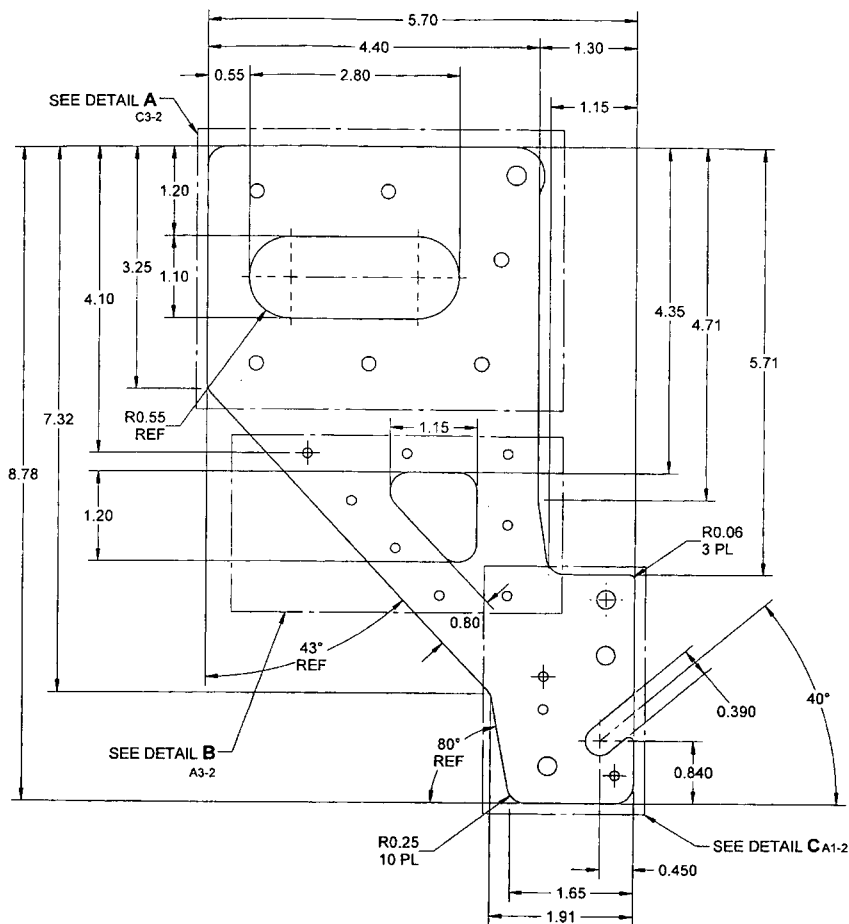
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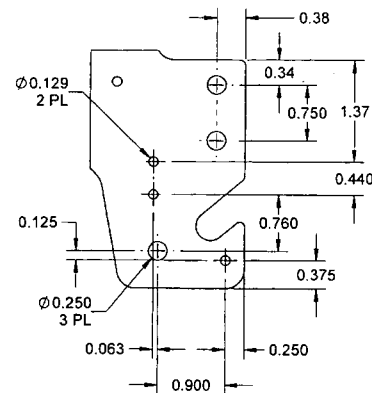
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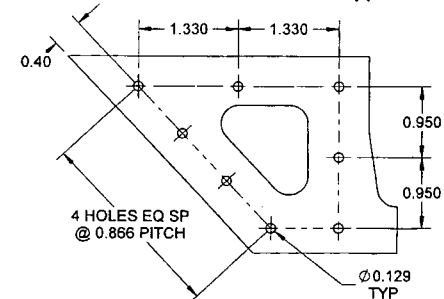
**NOTE:** Date & initial all entries



**DETAIL A** D8-2



**DETAIL B** B7-2



**DETAIL C** A4-2

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4419</b>	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 3	
APPROVED	<i>[Signature]</i>	TITLE <b>BASKET SUPPORT PLATES</b>	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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20606

RELEASED  
2011-07-28

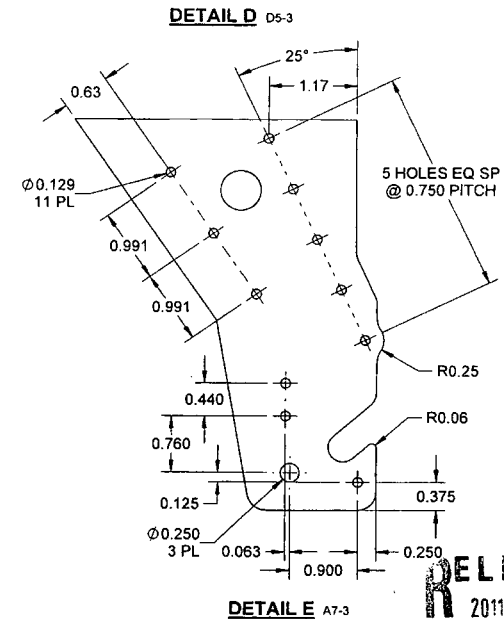
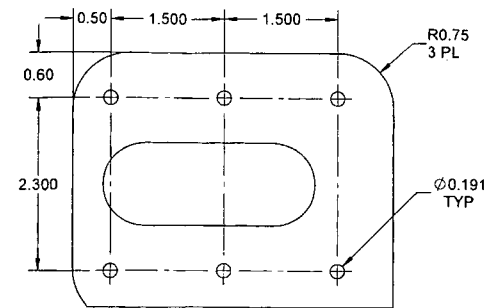
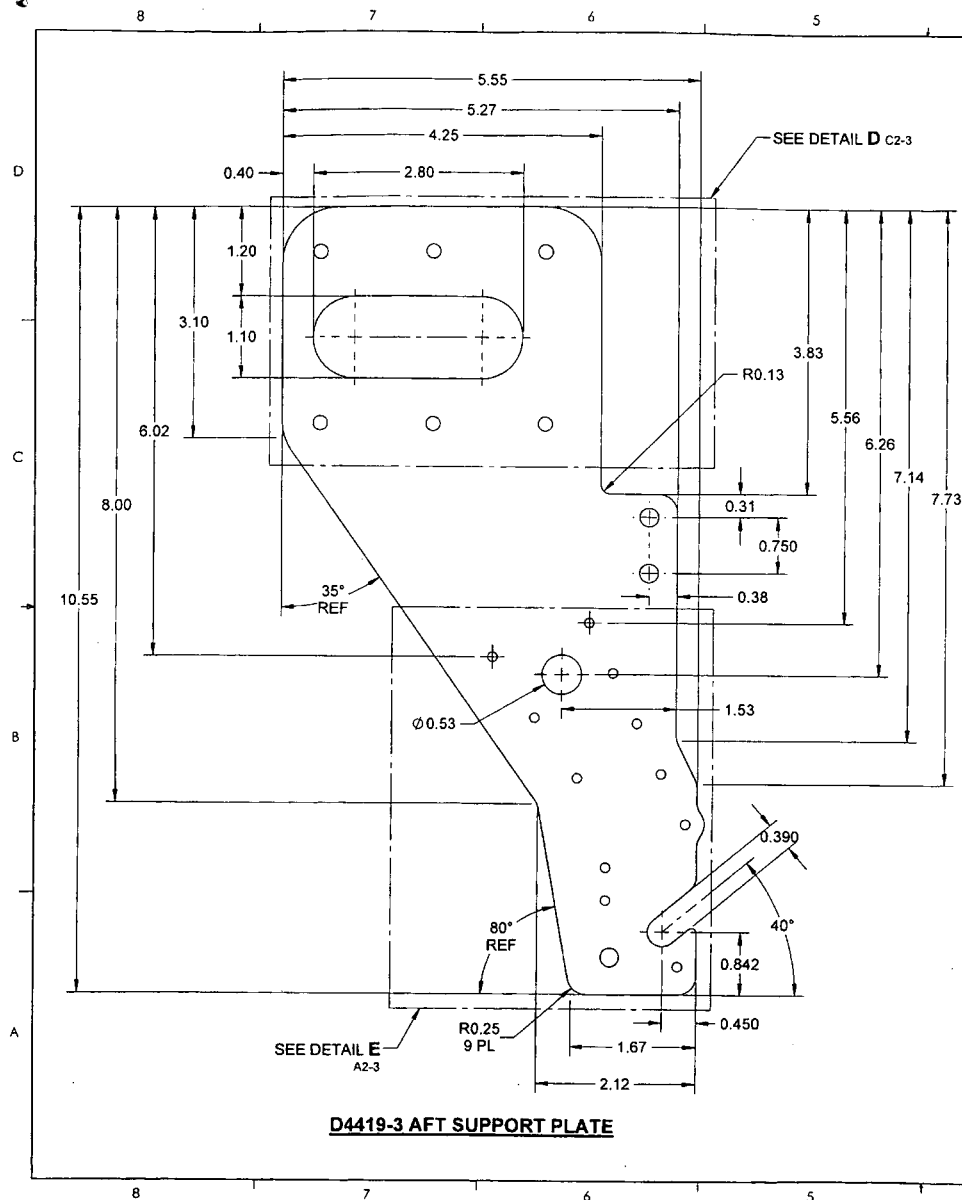
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DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D4419</b>	REV. A
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 3	
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BASKET SUPPORT PLATES</b>	NTS
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**RELEASED**  
2011-11-28  
JW

W/O:		WORK ORDER CHANGES					
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